

Work Order ID 66190

Monday, February 07, 2011 11:55:47 AM



Page 1

Item ID: D3407-1

Accept



Setup Start



Revision ID:

Item Name: Stem

Stop



Start Date: 2/8/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: ME

Date: 11-02-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3407	Rev E

100 DOOSAN LATHE 0.00



Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA596 Rev: E & Dwg D3407 Rev: E ☐ 2-Deburr

11/2/17

12 φ

110 QC2- Inspect parts off machine FAI/FAIB 0.00



QC

Memo

0.00

Quality Control

11/2/17

12 φ

120 QC8- Inspect parts - second check 0.00



QC

Memo

0.00

Quality Control

11/02/22

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3407-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Stem

Start Date: 2/8/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Packaging

Memo

0.00

11/2/22 JF (120)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

11/02/23 JF

ME
11-02-22

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Picklist Print

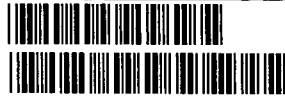
Monday, February 07, 2011 11:55:45 AM

Page 1

Work Order ID: 66190

Parent Item: D3407-1

Parent Item Name: Stem



Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 05.10.18 New issue KJ/EC
IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750 		Purchased	No			100	f	33.8950	0.366	4.623158		11/21/7	
17-4 round bar .750													

Location

Loc Qty

Loc Code

MAT

33.895

114488

9.895

116808

24

5.5 pt

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 66190
Description: Tow Ring		Part Number: D3407-1
Inspection Dwg: D3407	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	.073	/		U/L	SH-9
1/4-28 UNF	Max: 0.2668 Min: 0.2635	.265	/		M.C	SH-5
Major Ø	Max: 0.249 Min: 0.2425	.246	/			
Ø0.625	+/-0.010	Ø.625	/			
Ø0.363	+/-0.010	Ø.367	/			
Ø0.750	+/-0.010	Ø.750	/			
R0.100	+/-0.010	R.100	/		R.G.	
0.470	+/-0.010	.473	/			
0.500	+/-0.010	.507	/			
3.250	+/-0.010	3.250	/			
4.250	+0.000/-0.010	4.245	/			
5.270	+/-0.010	5.265	/			2nd Op
0.150	+/-0.010	.154	/			--
0.550	+/-0.010	.552	/			--
0.625	+/-0.010	.625	/			--
0.250	+0.010/-0.000	.255	/			--

Measured by: [Signature]	Audited by: [Signature]	Prototype Approval:	N/A
Date: 11/2/17	Date: 11/2/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	
B	07.07.18	Tolerances for diameters updated per Machinists	KJ/JLM	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	[Signature]

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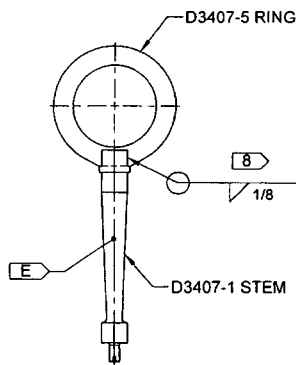
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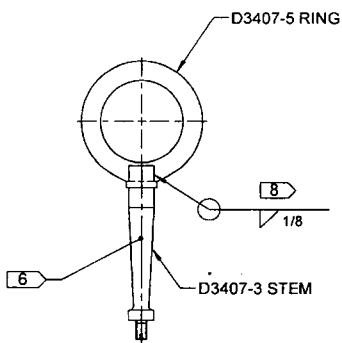
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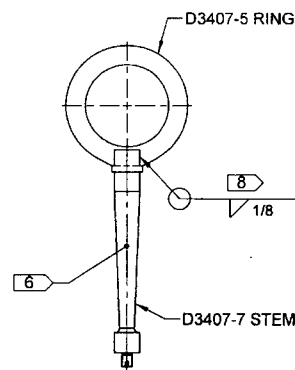
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



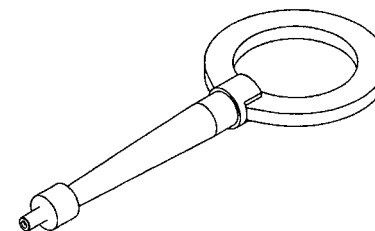
D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING



RELEASED

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

REV.	DESCRIPTION	BY	DATE
E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/-3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/-3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/-3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
DESIGN	DART AEROSPACE USA, INC.		
DRAWN	PORT HADLOCK, WA		
CHECKED	DRAWING NO. D3407	REV. E	
MFG. APPR.	TITLE TOW RING	SHEET 1 OF 5	
APPROVED	SCALE		
DE APPR.	NTS		
DATE	08.07.23		

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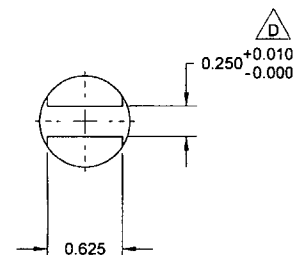
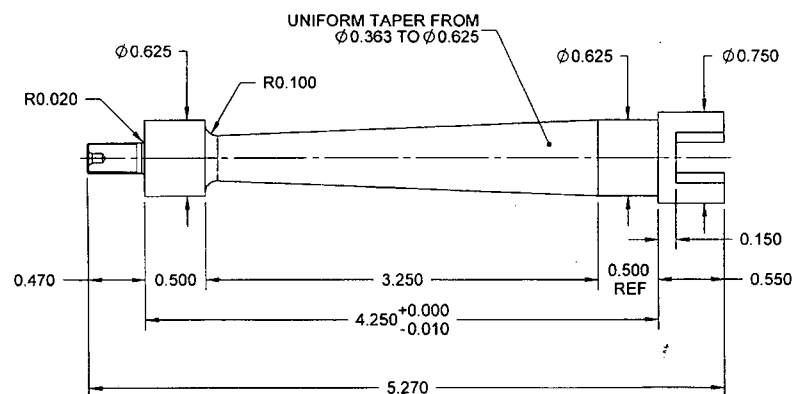
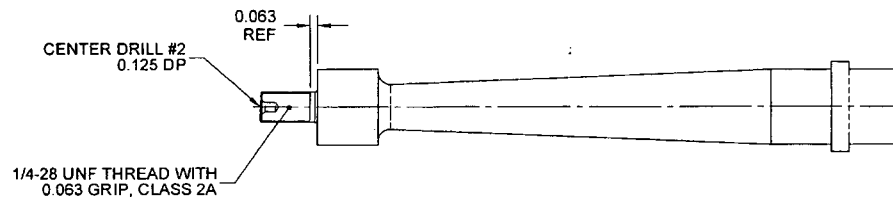
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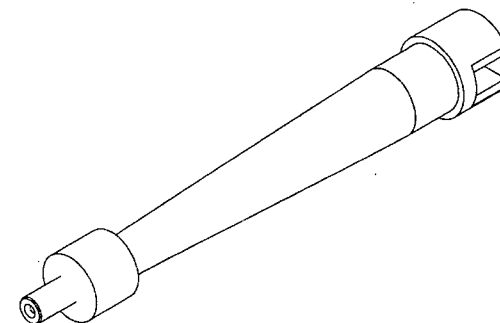


D3407-1 STEM

NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

#66190



RELEASED

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	<small>COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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